

Work Order ID 64198

Tuesday, November 30, 2010 10:41:06 AM

Page 1

Item ID: D3828-1KGY

Accept

Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3828

A

100

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

DL
10/12/16

105

0.00

HandThermo

Dry material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 KYDEX

Temp: *150*

Time IN: *4:30*

Time OUT: *7:00*

10/12/15
10/12/16

2

BB
10/12/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA052 using tool DT9228
Dwg Rev: A
Folio Rev: _____

2 BB

BB

10/12/16.

120

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

2 BB

BB

10/12/16.

130

0.00



QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

BB

Jh
10/12/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 64198

Tuesday, November 30, 2010 10:41:07 AM

Page 3

Item ID: D3828-1KGY

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Setup Start

Revision ID:

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Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

2

BB

12/12/21

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

2

BB

10/12/21

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

8, 10/12/23

(42)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 64198

Tuesday, November 30, 2010 10:41:07 AM

Page 4

Item ID: D3828-1KGY

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Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP64200

0.00

Packaging

11/30/10 3 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/04

11/01/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 30, 2010 10:41:06 AM

Page 1

Work Order ID: 64198



Parent Item: D3828-1KGY



Parent Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| MKYD6185S.080-P3- 52068 | | Purchased | No | | | | sf | 393.5600 | 2.7083 2.625 | 5.25 | | | |



Kydex steel grey



Location

Loc Qty

Loc Code

therm

393.56

111807

393.56

5.4166

10/17/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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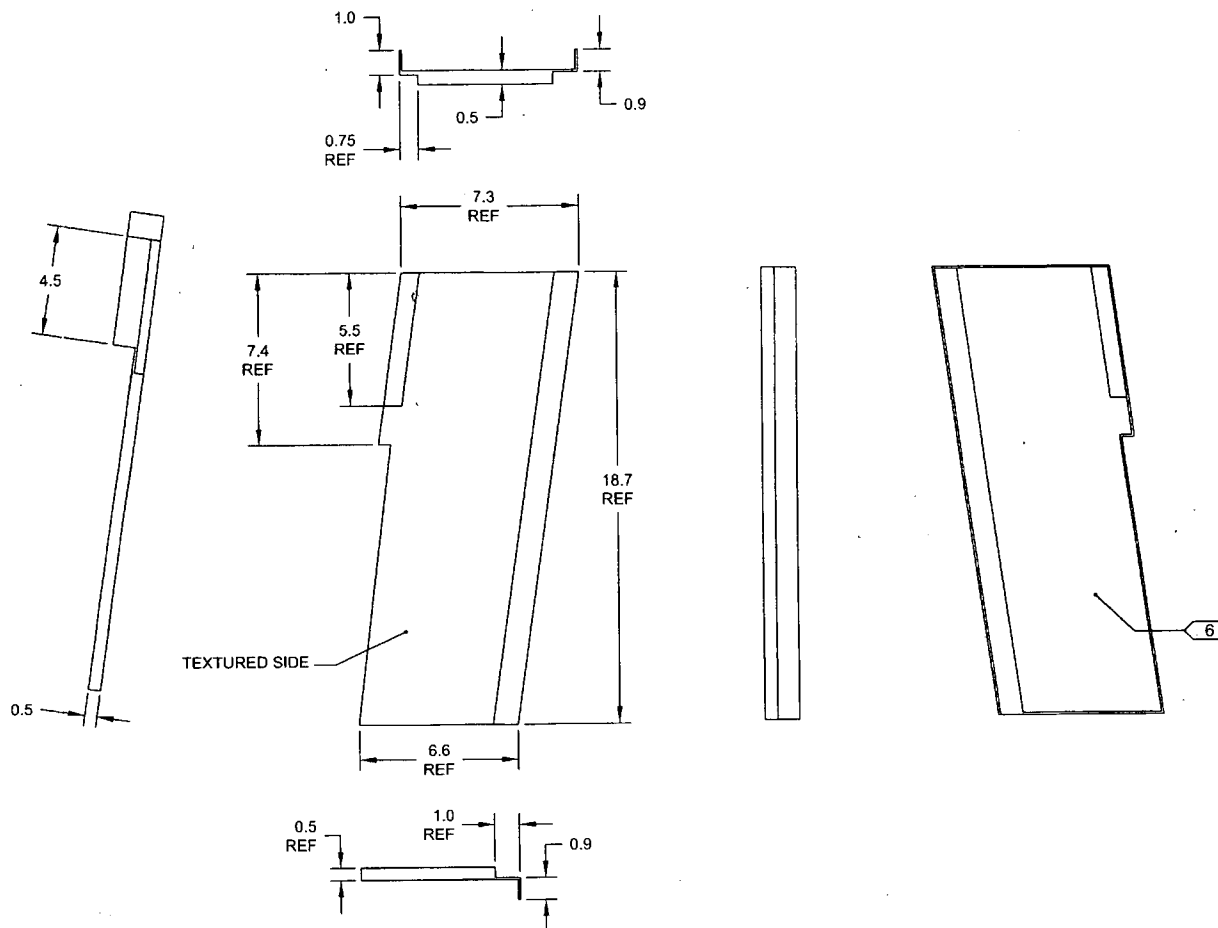
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

64198



D3828-1 VERTICAL TUNNEL, LOWER L/H

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9228 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3828-1KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3828-1KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| REV. | DESCRIPTION | PH | DATE |
|------------|-------------|----|----------|
| A | NEW ISSUE | BY | 09.06.12 |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.06.12 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3828
REV. A
SHEET 1 OF 2
TITLE VERTICAL TUNNEL (206 L/L1/L3/L4)
SCALE NTS

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RELEASED
09/06/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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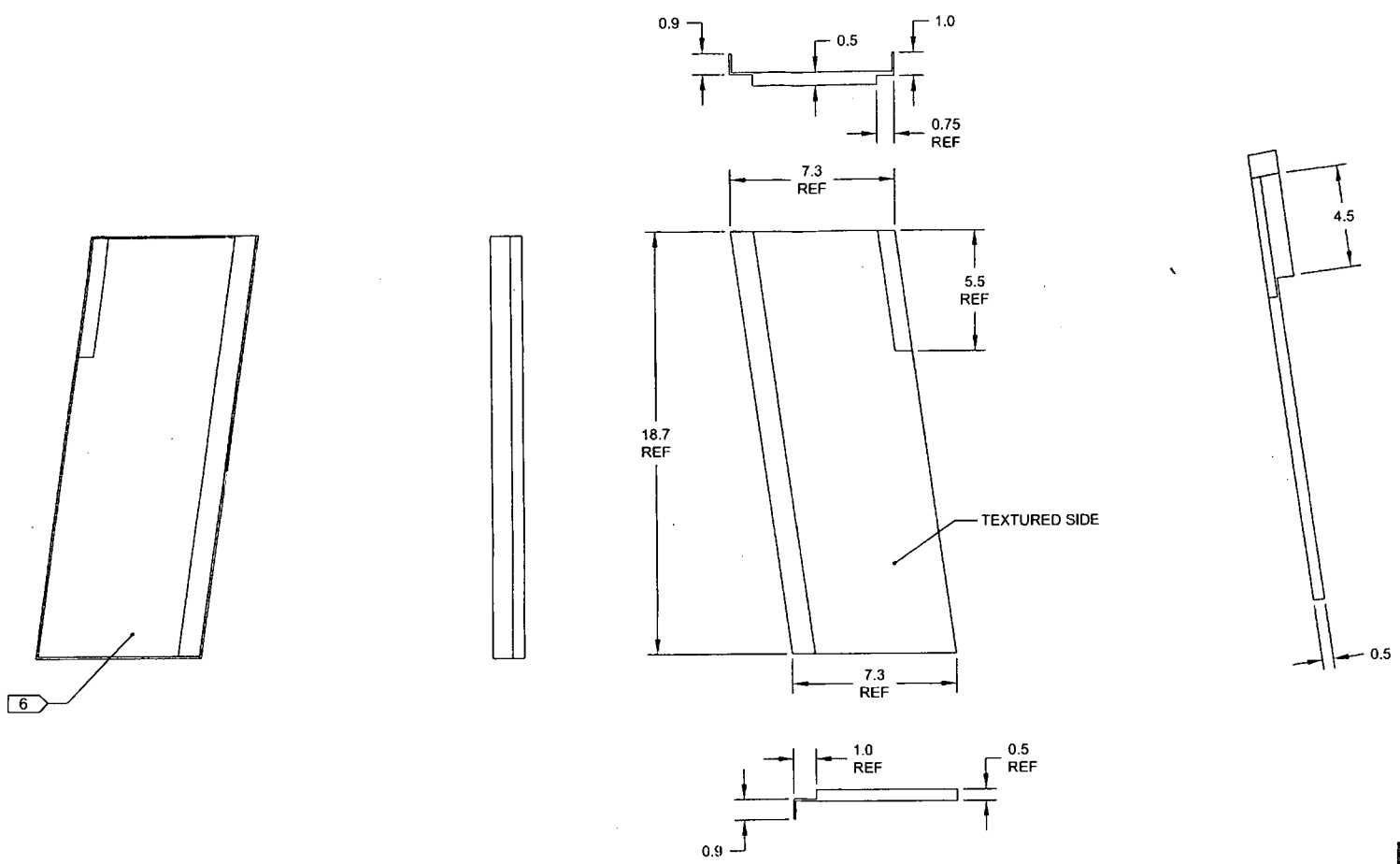
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

64198



D3828-2 VERTICAL TUNNEL, LOWER R/H

RELEASED
09/06/12

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.6 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9229 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3828-2KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3828-2KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| | | |
|------------|----------|--|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. A |
| MFG. APPR. | | D3828 SHEET 2 OF 2 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | VERTICAL TUNNEL (206 L/L1/L3/L4) NTS |
| DATE | 09.06.12 | COPYRIGHT © 2009 BY DART AEROSPACE LTD |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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|---------------------------|-------------|---------------------|--------------------|
| DART AEROSPACE LTD | | Work Order: | |
| | | | |
| Description: | | Part Number: | |
| | | | |
| Inspection Dwg: | Rev: | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than " | | | | |
| Shape Definition | | | | |
| Texture Retention | | | | |
| Material imperfections such as bumps, cracks, voids, scratching | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by:

Date:

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| | | | | | | |
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Measured by:

Date:

Audited by:

Date:

Preliminary Approval:

Date:

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| B | 10.04.14 | Added preliminary approval | KJ | |

10.04.14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | |
|--|--------|-------------------------|
| DART AEROSPACE LTD | | Work Order: 64198 |
| Description: VERTICAL TUNNEL lower L/W | | Part Number: D3828-1K4X |
| Inspection Dwg: 3828 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than _____" | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |

| | |
|------------------------|-----------------------|
| Measured by: <u>JB</u> | Date: <u>10/12/21</u> |
|------------------------|-----------------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 18.7 | REF | 18.75 | ✓ | | | |
| 7.3 | REF | 7.375 | ✓ | | | |
| 4.5 | ±.100 | 4.5 | ✓ | | | |
| 1.0 | ±.100 | 1.05 | ✓ | | | |
| .9 | ±.100 | 1.0 | ✓ | | | |
| .5 | ±.100 | .6 | ✓ | | | |
| .050 | M.I.D | .057 | ✓ | | | |
| | | | | | | |
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| | |
|-----------------------------|-----------------------|
| Measured by: <u>JB</u> | Date: <u>10/12/21</u> |
| Audited by: <u>S</u> | Date: <u>10/12/23</u> |
| Preliminary Approval: _____ | Date: _____ |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| B | 10.04.14 | Added preliminary approval | KJ | |

10-04-14